

Work Order ID 63016

Monday, October 18, 2010 8:55:01 AM



Page 1

Item ID: D206-667-103TRN

Accept



Setup

Start



Revision ID:

Item Name: Crosstube Turning DetailL

Stop



Start Date: 10/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/10/18

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-143	Rev C

100



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087
 2-Turn first side as per Folio FA087
 3-File down transition lines smooth.

110



QC1- Inspect dimensions to dimension sheet

0.00

Quality Control

Memo

0.00

120



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA087
 2-File down transition lines smooth.

 3-Remove sand and plugs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

QC

Quality Control

Operation
Description

QC1- Inspect dimensions to dimension sheet

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
 10/10/21

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

150

HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00



Hand Finishing Crosstubes

0.00

 10/10/25




W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Number

10-10-25

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

170



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack Location: LG

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, October 18, 2010 8:55:04 AM

Page 1

Work Order ID: 63016



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6002-115		Manufactured	No			110	Each	50.0000	1	1			

Crosstube Material



Location	Loc Qty	Loc Code
LG	50	
34684	1	
34776	49	

SD 10/18/2010

W/O:		WORK ORDER CHANGES					
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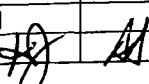
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	13016
Description: Crosstube Assembly (206L High Fwd)		Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	/		
	1.982	+0.005/-0.000	1.984	/		
	2.019	+0.005/-0.000	2.023	/		
	2.058	+0.005/-0.000	2.063	/		
	2.097	+0.005/-0.000	2.107	/		
	2.136	+0.005/-0.000	2.138	/		
	2.176	+0.005/-0.000	2.187	/		
	2.201	+0.005/-0.000	2.205	/		
	0.125	+/-0.010	0.125	/		
	0.400 x 30°	+/-0.010	400x30°	/		
	R0.063	+/-0.010	0.063	/		
	R0.500	+/-0.010	0.500	/		
	4.438	+/-0.030	4.438	/		
	104.98	+/-0.020	105.00	/		
SIDE B	2.240	+0.005/-0.000	2.245	/		
	1.982	+0.005/-0.000	1.986	/		
	2.019	+0.005/-0.000	2.023	/		
	2.058	+0.005/-0.000	2.062	/		
	2.097	+0.005/-0.000	2.102	/		
	2.136	+0.005/-0.000	2.141	/		
	2.176	+0.005/-0.000	2.181	/		
	2.201	+0.005/-0.000	2.206	/		
	0.125	+/-0.010	0.125	/		
	0.400 x 30°	+/-0.010	400x30°	/		
	R0.063	+/-0.010	0.063	/		
	R0.500	+/-0.010	0.500	/		
	4.438	+/-0.030	4.438	/		

Measured by:		Audited by:	Y. A	Preliminary Approval:	N/A
Date:	10/10/21	Date:	10/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

D

D

Item	Qty	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHIN 10 DAYS
NO. *206-667-143*
PS 10/10/18

RELEASED
08/11/18

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUTDUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION		BY DATE
DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	<i>Q</i>	D206-667-143	SHEET 1 OF 4
MFG. APPR.	<i>Q</i>	TITLE	SCALE
APPROVED	<i>Q</i>	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DE APPR.	<i>Q</i>	DATE	08.11.06

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

A

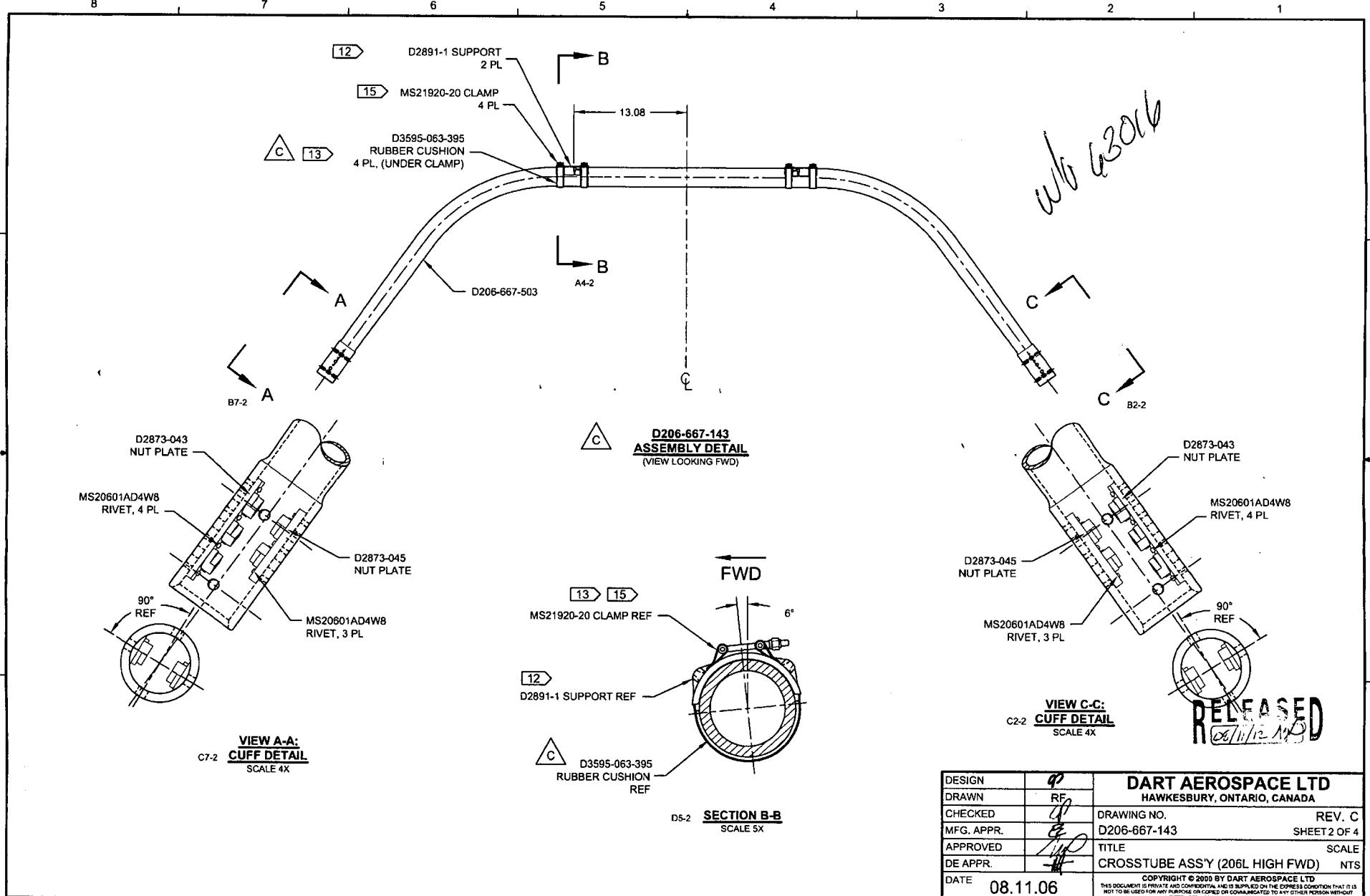
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DESIGN	49	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO.
MFG. APPR.	EP	REV. C
APPROVED	AP	D206-667-143
DE APPR.	AP	SHEET 2 OF 4
DATE	08.11.06	TITLE
		CROSSTUBE ASS'Y (206L HIGH FWD) NTS
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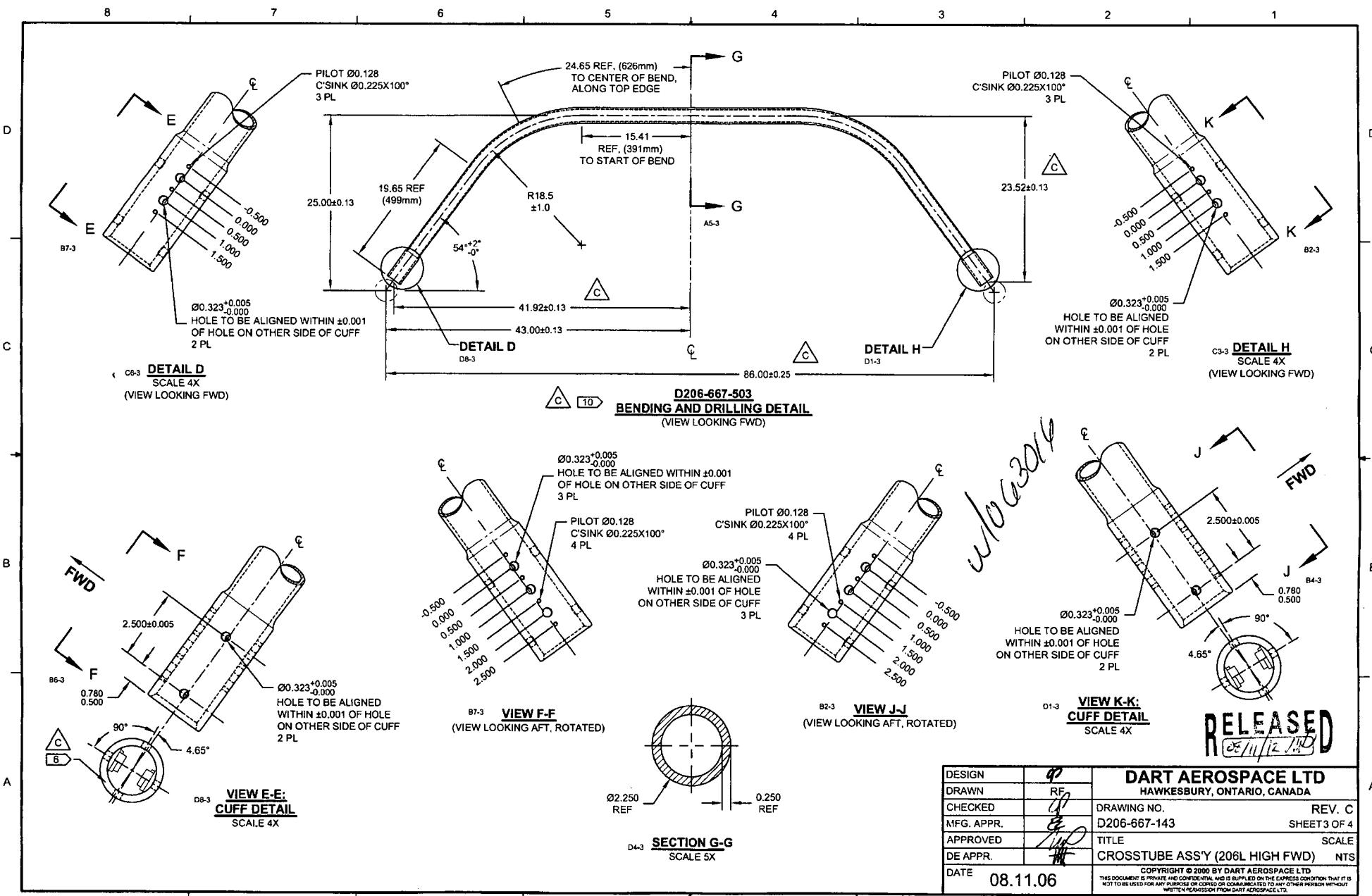
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DRAWN	RF			
CHECKED	CP	DRAWING NO.	REV. C	
MFG. APPR.	EG	D206-667-143	SHEET 3 OF 4	
APPROVED	LM	TITLE	SCALE	
DE APPR.	HF	CROSSTUBE ASS'Y (2061 HIGH FWD) NTS		
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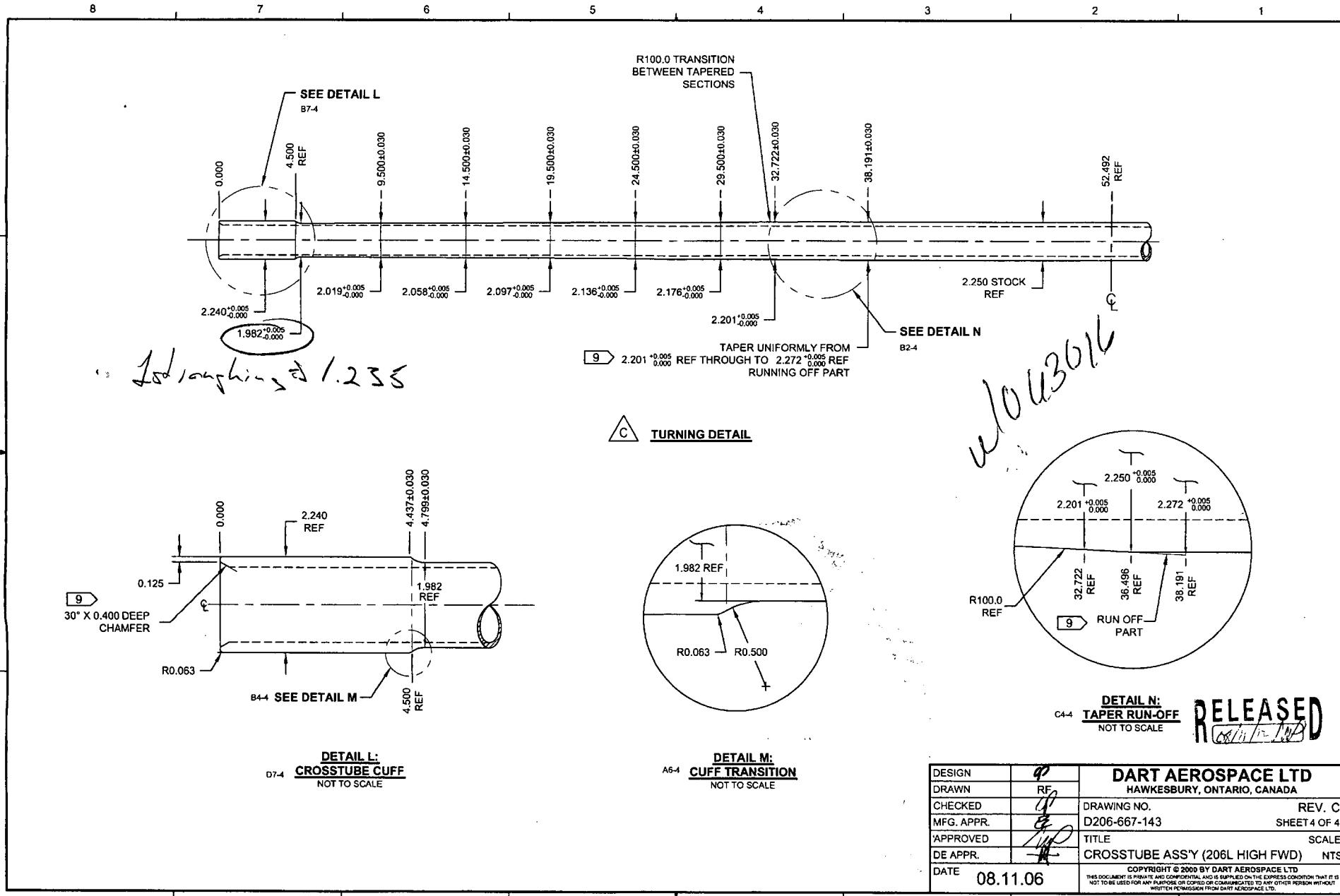
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DRAWN	RF		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	SP	D206-667-143	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
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